



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3196-4
Job Sheet 191870



Part No: D3196-4

Job Qty: 6 pcs

Part Name: Bar



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 4/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev: A New Issue 05-11-08 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Supplier		
100	Bandsaw - 1	6 pcs	4/10/19	4/10/19	0.00	0.04	Bandsaw - 1		52 9-89	19/05/27
110	HAAS 4 Axis - B4B	6 pcs	4/10/19	4/10/19	0.96	5.98	HAAS - 1 - B4B		52 9-89	19/05/27
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	6 pcs	4/10/19	4/10/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 54			
							QC 2 - 56			



Container No: S184241



Part: D3196-4

Job No: 191870

Serial No/Batch: S184241

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 05/27/19

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130 QC 8	6 pcs	4/10/19	0.00 0.00	QC 2 - 57				
				QC 2 - 62				
				QC 2 - 63				
				QC 2 - 8				
				QC 2 - 66				
				QC 2 - 64				
				QC 2 - 65				
				QC 8 - 12				
				QC 8 - 14	19/05/30			
				QC 8 - 17				
				QC 8 - 20				
				QC 8 - 25				
				QC 8 - 3				
				QC 8 - 32				
				QC 8 - 33				
				QC 8 - 35				
				QC 8 - 39				
				QC 8 - 4				
				QC 8 - 44				
				QC 8 - 45				
				QC 8 - 49				
				QC 8 - 58				
				QC 8 - 8				
				QC 8 - 9				
				QC 8 - 68				
				QC 8 - 67				
				QC 8 - 1 (A)				
				QC 8 - 47				
				QC 8 - 40				
140 Handfinish - 1-1 Chemical- B4B	6 pcs	4/10/19	0.00 0.50	Handfinish - 1 - 1 - B4B				
				Handfinish - 1 - 2 - B4B				
				Handfinish - 1 - 3 - B4B	★ MAY 31 2019			
				Handfinish - 1 - 4 - B4B				
				Handfinish - 1 - 5 - B4B				
				Handfinish - 1 - 6 - B4B				
				Handfinish - 1 - 7 - B4B				
				Handfinish - 1 - 8 - B4B				
				Handfinish - 1 - 9 - B4B				
				Handfinish - 1 - 10 - B4B				
				Handfinish - 1 - 11 - B4B				
				Handfinish - 1 - 12 - B4B				
				Handfinish - 1 - 13 - B4B				
				Handfinish - 1 - 14 - B4B				
				Handfinish - 1 - 15 - B4B				
				Handfinish - 1 - 16 - B4B				
				Handfinish - 1 - 17 - B4B				
				Handfinish - 1 - 18 - B4B				
				Handfinish - 1 - 19 - B4B				
				Handfinish - 1 - 20 - B4B				
				Handfinish - 1 - 21 -				
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				B4B		
				Handfinish - 1 - 22 - B4B		
150	Powdercoat - 3 Grey Sand - B4B	6 pcs	4/10/19	0.00 0.36	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
160	QC 3	6 pcs	4/10/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 6		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
170	Packaging 3-1 - Stock - B4B	6 pcs	4/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		

B4 19-6-3

150 Powdercoat - 3 Grey Sand - B4B M 138834
 START: 3:00 CUT: 3:00 FINISH: 3:50

DAS
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 9-89

PC ST 256

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	6	4/10/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - (Bandsaw) ***INSPECT MATERIAL FOR DEFECTS BEFORE CUTTING*** Cut blank: (0.75" x 1.50") x 34.750"
 Descriptions: long Bar

- 110 - (HAAS CNC Vertical Machine) 1-Machine D3196-4 as per Folio FA339 and Dwg D3196 Identify as D3196-4
- 120 - (QC2- Inspect parts off machine FAI/FAIB)
- 130 - (QC8- Inspect parts - second check)
- 140 - (Chemical Conversion Coat per QSI005 4.1)
- 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
- 160 - (QC3- Inspect Part Finish)
- 170 - (Identify as per dwg & Stock Location: _____)
- 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X01.500	6061-T6 Bar .750 X 1.50	17.2200 ft (2.87 ea)	100-Bandsaw - 1	5168972

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.750X01.500	17	41	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bar	34.625inches $\pm$ 0.010	34.635 34.615	34.625	
2	Bar	33.650inches $\pm$ 0.010	33.660 33.640	33.650	
3	Bar	16.639inches $\pm$ 0.010	16.649 16.629	16.639	
4	Bar	0.488inches $\pm$ 0.010	0.498 0.478	0.488	
5	Bar	0.962inches $\pm$ 0.005	0.967 0.957	0.963	
6	Bar	0.464inches $\pm$ 0.010	0.474 0.454	0.463	
7	Bar	0.504inches $\pm$ 0.010	0.514 0.494	0.503	
8	Bar	0.344inches $\pm$ 0.006 - 0.001	0.350 0.343	0.345	Diameter
9	Bar	0.660inches $\pm$ 0.008 - 0.001	0.668 0.659	0.662	Diameter
10	Bar	100.000Degrees $\pm$ 0.500	100.500 99.500	100°	
11	Bar	0.512inches $\pm$ 0.005	0.517 0.507	0.512	
12	Bar	0.060inches $\pm$ 0.010	0.070 0.050	0.06	
13	Bar	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	
14	Bar	4.750inches $\pm$ 0.010	4.760 4.740	4.754	
15	Bar	12.531inches $\pm$ 0.010	12.541 12.521	12.535	
16	Bar	16.627inches $\pm$ 0.010	16.637 16.617	16.630	
17	Bar	21.844inches $\pm$ 0.010	21.854 21.834	21.848	
18	Bar	29.625inches $\pm$ 0.010	29.635 29.615	29.629	
19	Bar	0.250inches $\pm$ 0.010	0.260 0.240	0.250	
20	Bar	1.000inches $\pm$ 0.010	1.010 0.990	1.000	
21	Bar	0.125inches $\pm$ 0.010	0.135 0.115	0.125	Radius
22	Bar	0.987inches $\pm$ 0.010	0.997 0.977	0.985	
23	Bar	0.500inches $\pm$ 0.010	0.510 0.490	0.498	

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M6061T6B0.750X01.500
S168972

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					